

DART AEROSPACE LTD		Work Order:	178814
Description: upper end swivel		Part Number:	SWA25A-200
Inspection Dwg: SWA25A-200	Rev: 6	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	+0.015 / -0.000	1.530	✓		Mic LPO5	
.03 x 45°	±.01 x .5°	.04 x 45°			Vern LPO8	
R.031	+0.000 / -0.005	.031			Rad gage	
.04 x 45°	±.01 x .5°	.045 x 45°			Vern LPO8	
3 1/2 -16 UN-2A						
Max Ø3.4936	±.0047	3.4945			104-137	
Wire Ø.040					↓	
DDW 3.5207	±.0029	3.523			↓	
1.125	+0.000 / -0.005	1.1225			Mic LPO2	
6.843	±.005	6.842			H.G.	
1.350	±.005	1.351	✓		↓	
Ø2.700	±.005	2.6995			Mic LPO3	
1.370	±.005	1.370			"	
1.150	±.005	1.150			"	
.434	±.005	.434	✓		"	
R.22	±.01	2.198			Vern LPO8	
10-32 UNF-2B	GO - NO GO	GO				
.25	±.01	.260			Vern LPO8	
R.25	±.01	.250	✓		Rad gage	
Ø.500	±.005	.499			gage pin	
1.35	±.01	1.350				
.820	±.005	.822			Vern LPO8	
3.70	±.01	3.702	✓		H.G.	
3.25	±.01	3.250			↓	
3.100	±.005	3.100			↓	
2.125	±.005	2.125			Vern LPO8	
.75 x 45°	±.01 x .5°	.755 x 45°	✓		↓	
R.13	±.01	R.130	✓			
.04 x 45°	±.01 x .5°	.05 x 45°	✓		Vern LPO8	

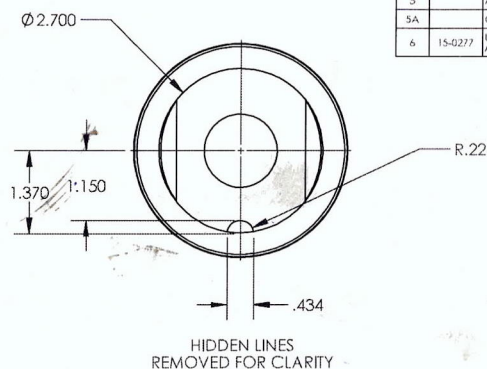
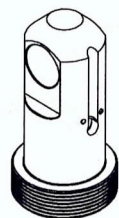
Measured by:	Checked by:	QC Inspector:
Date: 18-06-19	Date:	Date:

Engineering Approval: (If necessary)	Date:
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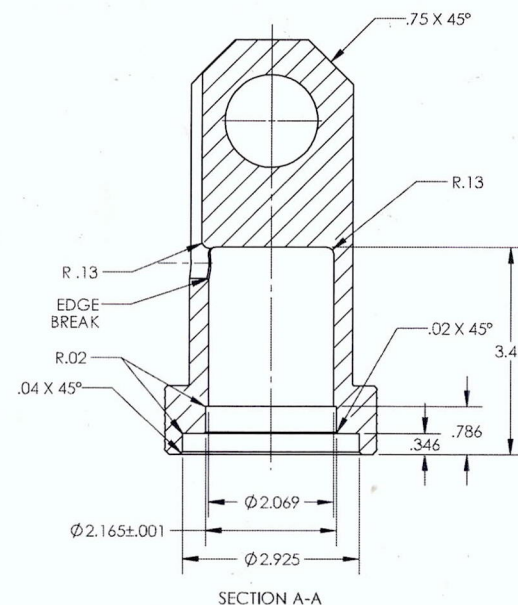
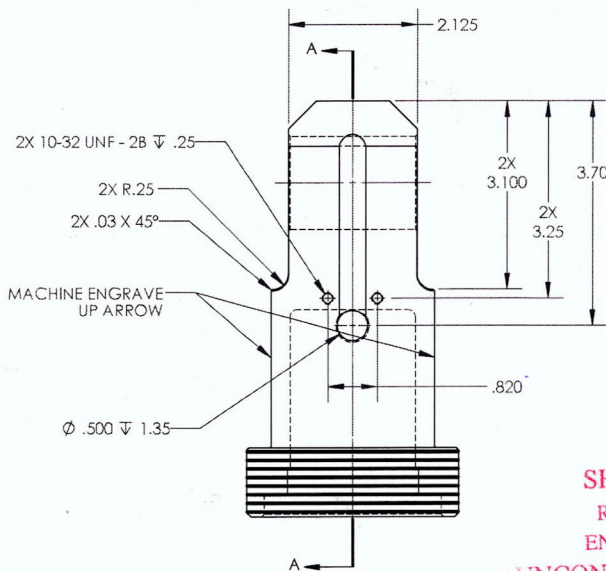
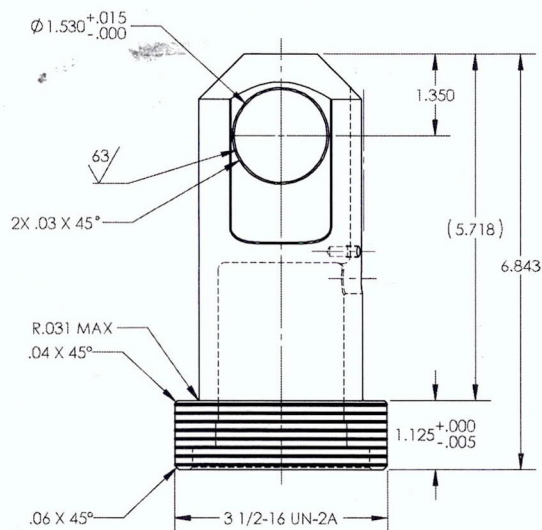
Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
5		AS DRAWN BY CANAM	11/12/2012	JAG
5A		CHD B/O INFO. TO BLANK	4/29/2014	JAG
6	15-0277	UPDATED TO NEW DRAFTING STANDARDS. ADDED UP ARROW NOTE. ADDED MATL OPTION H1075. ADDED DIMS FROM SWA10A-200 BLANK DWG.	9/22/2015	DPD



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NO. 178814 MLC
180608

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA25A-200	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	

DART AEROSPACE	
TITLE: UPPER END SWIVEL	
DWG NO.: SWA25A-200	REV: 6
MATL: SS 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>P. Muel</i>
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 X 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: 1:2	DATE: 2/22/2002
SHEET 1 OF 1	